Selectarc WELDING

SELECTARC Inox 316VD

Stainless Steel Electrode for Vertical Down

Classification

AWS A5.4 : E316L - 16
ISO 3581- A : E 19 12 3 L R 31
EN 1600 : E 19 12 3 L R 31

Approvals : CWB

Characteristics

Low carbon Rutile-basic coated electrode, giving a Mo-containing austenitic stainless steel deposit. This electrode is designed for vertical down welding on Cr-Ni-Mo stainless steels and clad steels which are applied at service temperature from - 120°C upto + 400°C

Applications

Stainless steels for General use, Chemical and Petrochemical Industries, Refineries.....

Base materials

UNS	ALLOY	EN 10088	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo 17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo19-11-2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19-11-2	1.4581	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.029	0.80	0.70	18.00	11.50	2.50	0.018	0.022	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5	Impact (KV) Temp.°C	J	FN (WRC)
AW	570	410	31	+ 20	60	5

Welding Current & Instructions

Electrode	ØxL (mm)	2.0 x 300	2.5 x 300	3.2 x 350
Current	(A)	40 - 50	60 - 70	100 - 110

Redrying of Electrode for 1 hr at 250°C before use. Maintain Interpass temperature : < 200°C

1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

AC/+	~ 70V

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